

Work Order ID 83366

April-17-12 2:23:35 PM

83366

Page 1

Item ID: D3912-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Eyebolt Block

Start Date: 17/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/17

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3912	B								
100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 2.50" LONG								
110		0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA870 AND DWG								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>B</u>								
	DEBURR								

OK 12/04/17

13

B.A 12/04/21

13

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NOTE: Date & initial all entries

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Page 3

Item ID: D3912-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Eyebolt Block

Stop ***NS2***

Start Date: 17/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

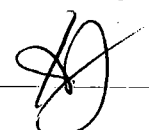
170

QC

Memo

0.00

Quality Control

12/4/23 

11204-23

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NOTE: Date & initial all entries

Picklist Print

April-17-12 2:23:39 PM

Page 1

Work Order ID: 83366

83366

Parent Item: D3912-3

D3912-3

Parent Item Name: Eyebolt Block

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			100	f	17.5105	0.208	2.627368			

M303B1 000X1 000

**

303 BAR 1" X 1"

Location

Loc Qty

Loc Code

MAT050

17.510526

120602

17.510526

2.63 and 12/04/12

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

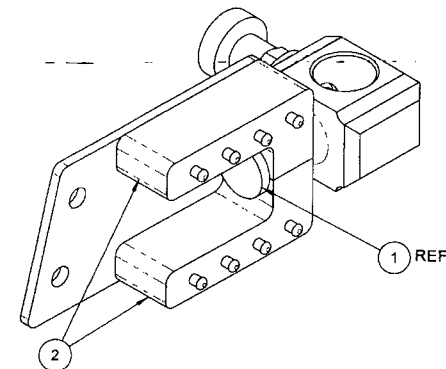
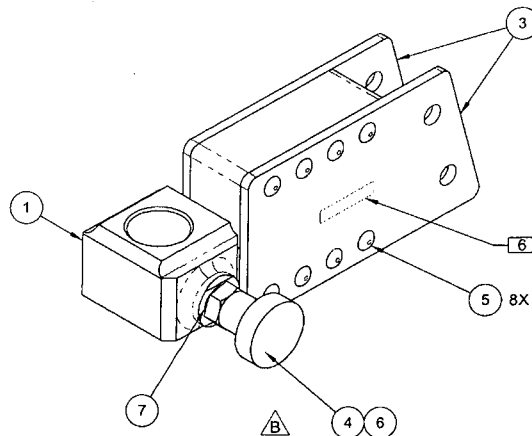
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	-8-	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

NO
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

83366 MLJ
12/04/17

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

REV.	DESCRIPTION	BY	DATE
B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV: MS21209-F615 WAS MS21209-0810 HELICAL; (1) WASHER NAS1149C0663R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B	SHEET 1 OF 3
DRAWN	D3912	SCALE	NTS
CHECKED		TITLE	EYEBOLT RECEIVER ASSY
MFG. APPR.		DATE	10.06.28
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NOTE: Date & initial all entries

Technical drawing of a mechanical part, showing front and top views with dimensions and tolerances.

Front View (Top):

- Overall width: 2.23
- Top flange width: 1.20
- Top flange thickness: 0.625
- Overall height: 1.72
- Central hole diameter: $\phi 0.500$
- Left flange diameter: $\phi 0.700$
- Left flange thickness: 0.13
- Top flange radius: R0.13
- Left flange radius: R0.015
- Bottom flange thickness: 0.90 REF
- Bottom flange radius: 0.13 X 45° CHAM 4 PL
- Bottom flange height: 0.22
- Bottom flange reference height: 0.75 REF
- Bottom flange total height: 0.970
- Feature control symbol: $\triangle B$

Top View (Bottom):

- Overall width: 1.100
- Overall height: 1.100
- Central hole diameter: $\phi 0.650$
- Top flange width: 0.625
- Top flange thickness: 0.44
- Left flange diameter: $\phi 0.700$
- Left flange thickness: 0.13
- Left flange radius: R0.015
- Bottom flange thickness: 0.90 REF
- Bottom flange radius: 0.13 X 45° CHAM
- Bottom flange height: 0.22
- Bottom flange reference height: 0.75 REF
- Bottom flange total height: 0.970
- Feature control symbol: $\triangle B$


Sectional View (Left):

- Section line: A-A
- Section symbol: B2-3 A
- Section line: C SYMM

Technical drawing of a mechanical part, likely a valve body, showing a cross-section. The part has a central bore and a flange. Key dimensions include: outer diameter $\phi 0.719^{+0.010}_{-0.000}$, flange thickness 0.11, total height 0.88, and a central bore diameter of $\phi 2.00$. The part is symmetrical about a vertical centerline. Surface finish is R0.13 typical. The part is made of MS21209-F615 material and has a helical insert. A stock reference is indicated by a triangle symbol. A chamfer of 0.030 x 45° is shown on the bottom edge. A 0.13 x 45° chamfer is also indicated on the right side. The part is labeled with "DRILL & TAP 3/8-24 FOR MS21209-F615 HELICAL INSERT".

RELEASED
2010-07-16
MD

- NOTES:**
1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT: 0.45 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3912	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	EYEBOLT RECEIVER ASSY	NTS	
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NOTE: Date & initial all entries

[illegible]

NOTES:

- NOTES**
- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
 -5: 0.24 lbs

RELEASED
2010-07-16

DESIGN	<i>A/S</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3912	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EYEBOLT RECEIVER ASSY	NTS
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